

# Work Order ID 60295

July 1, 2010 12:38:40 PM

Page 1

Item ID: D3209-041

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 02/07/2010 Start Qty: 4.00

Required Date: 29/07/2010 Req'd Qty: 4.00

Reference: *10.07.01*

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3209	Rev A								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

*aml 10/07/08*

*4 0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1

☐

Deburr and Tumble

*aml 10/07/14*

*4 0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*aml 10/07/14*

*4 0*

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July 1, 2010 12:38:40 PM



Page 2

Item ID: D3209-041

Accept



Setup

Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 02/07/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 29/07/2010 Req'd Qty: 4.00

Customer:

Reference:

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

MJF  
10/07/14

4

8

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 BR 10-7-15

150

Grey Sandtex(Ref:4.3,5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M112588

Note: Cover the hole for D3209-1 before powder coat ☐ START TIME: 8:05 ☐ OVEN TEMPERATURE: 300° ☐ FINISH TIME: 8:33

8:33

14 BR 10-7-15

# Work Order ID 60295

July 1, 2010 12:38:40 PM



Page 3

Item ID: D3209-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 02/07/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 29/07/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

161

QC3- Inspect Part Finish

0.00



Small Fab

Memo

0.00

Small Fab

press fit bushing as per dwg

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

MS

10/07/15

X4

0

Ep 10/07/26 (4)

(X4)

# Work Order ID 60295

July 1, 2010 12:38:40 PM



Page 4

Item ID:	D3209-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket Assembly					
Start Date:	02/07/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	29/07/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>22</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
190	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

10-7-24 4258

10/07/28 98

10-7-27 (4)

# Picklist Print

July 1, 2010 12:38:39 PM

Page 1

Work Order ID: 60295

Parent Item: D3209-041

Parent Item Name: Bracket Assembly

Start Date: 02/07/2010

Required Date: 29/07/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A ☐ 04.06.09 ☐ New issue ☐ KJ/RF ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3209-3      Manufactured      No



Bushing

100

Each

47.0000

1

4

Location

Loc Qty

Loc Code

ST045

47

35633

6

40930

41

M6061T6B1.500X01.25

Purchased

No

170

f

41.8448

0.175

0.736842

0



6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT10

41.8448

→ 107461

12

110936

29.8448

0.73685

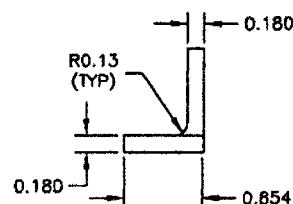
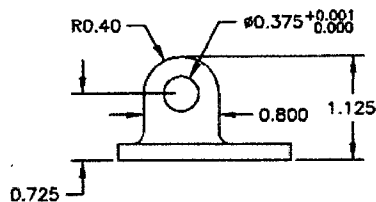
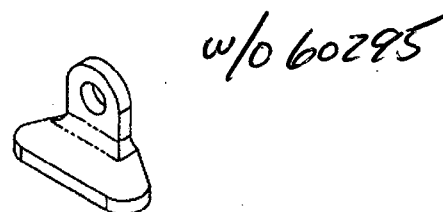
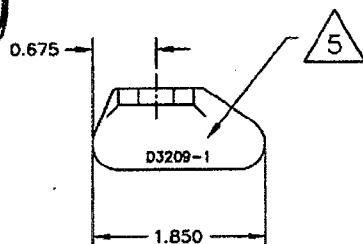
only 16/07/08



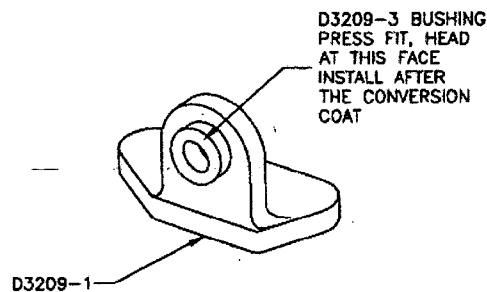
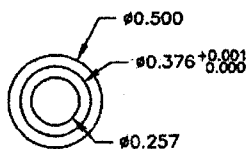
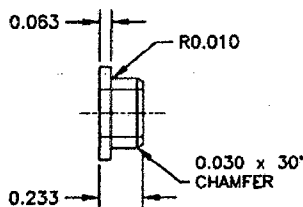


DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
04.04.05 [Signature]



**D3209-1 BRACKET**



**D3209-041 ASSEMBLY**



**D3209-3 BUSHING  
SCALE 1:2**

**D3209-1 BRACKET: D3209-3 BUSHING**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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